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D4149-1**Job Sheet 198582**

48

DAG
21
9-25

Part No: D4149-1**Job Qty:** 50 pcs**Part Name:** Crosstube Lug Plate, Aft**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/31/19**Job Tracking No:****Due Date:** 9/9/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.03.03 as per revC DD verf:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	50 pcs	9/9/19	9/9/19	0.17	7.63	Waterjet - Flow	8/19/19	JRB
110	QC 2	50 pcs	9/9/19	9/9/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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120 QC 8	50 pcs	9/9/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	8/19/19
				QC 8 - 12	JRB
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	AUG 21 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Packaging 3-1 - Stock - B4B	50 pcs	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

DAS
40
9-89

AUG 21 2019

STO80

Wed 8-21-2019
Oscar

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	50 pcs 48	9/9/19	0.00 0.00	QC 21 - SA - 21 → ST 080
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S11GA	304/316 0.125 Sheet	6.7750 sf (.1355 ea)	100-Waterjet - Flow - 1	5204167	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S11GA	7	37	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	198582
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	/		DC-02	
Ø0.191	+0.005/-0.001	0.190	/		DC-01	
Ø0.257	+0.006/-0.001	0.257	/			
Ø0.38	+0.006/-0.001	0.379	/			
0.380	+/-0.010	0.379	/			
0.469	+/-0.010	0.471	/			
0.310	+/-0.010	0.308	/			
0.750	+/-0.010	0.753	/			
3.25	+/-0.030	3.26	/			
0.65	+/-0.030	0.64	-			
0.63	+/-0.030	0.63	-			
5.46	+/-0.030	5.45	-			
3.80	+/-0.030	3.85	-			
2.13	+/-0.030	2.15	-			
1.313	+/-0.010	1.313	/			
0.625	+/-0.010	0.625	/			
0.375	+/-0.010	0.373	-			
1.175	+/-0.010	1.178	-			
0.752	+/-0.010	0.752	-			
1.588	+/-0.010	1.585	-			
1.587	+/-0.010	1.586	-			
11.15	+/-0.030	11.16	/			
0.750	+/-0.010	0.751	/			
1.55	+/-0.030	1.60	-			
1.12	+/-0.030	1.10	-			
8.42	+/-0.030	8.43	-			
2.70	+/-0.030	2.72	-			
0.125	+/-0.010	0.125	/			
Ø0.252	+0.003/-0.000	0.253	/			

Measured by:	JRB
Date:	8/19/19

Audited by:	DAS 40 9-89
Date:	AUG 21 2019

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:					



AEROSPACE

Container No: S206908



Part: D4149-1

Job No: 198582

Serial No/Batch: S206908

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/19/19